

Date: Tuesday, 8/21/2007 3:43:24 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: JACK SADDLE	
Job Number	: 34181		Part Number	: D2281	
Estimate Number	: 11177		Drawing Number	: D2281 REV G	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 8/21/2007 S.O. No. : N/A		Drawing Revision	: G	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 9/20/2007	
Previous Run	: 33828		Qty:	100	Um: Each
Written By					
Checked & Approved By					
Comment	: Est Rev:A Removed from 9 Digit 05-12-02 JLM				
	Est: rev B 06.07.17 waterjet EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S14GA	304SS .080
Comment: Qty.: 0.1313 sf(s)/Unit Total : 13.1250 sf(s) 304SS .080 batch: M105112 HB 07-08-23		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2281 Dwg Rev: G Prog Rev: G		
2-Deburr if necessary <span style="float: right;">A.m 07.08.30</span>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <span style="float: right;">(10)</span>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: Deburr <span style="float: right;">(10)</span>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes    No    DQA:    Date: 07/09/25  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		/						

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 3:43:24 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: JACK SADDLE

Job Number: 34181

Part Number: D2281

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Form as per D2281 using D2281-T2

SB 07/09/24 110

7.0 QC5 INSPECT WORK TO CURRENT STEP



Comments 110

Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/05

110

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: \_\_\_\_\_

07/09/25 110

9.0 QC21 FINAL INSPECTION/W/O RELEASE



110

Comment: FINAL INSPECTION/W/O RELEASE

Do 10/1/05

Job Completion



u 07/09/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		/						

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>34181</b>
<b>Description:</b> Jack Saddle	<b>Part Number:</b>	<b>D2281</b>
<b>Inspection Dwg:</b> D2281 <b>Rev:</b> G		<b>Page 1 of 1</b>

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article Prototype

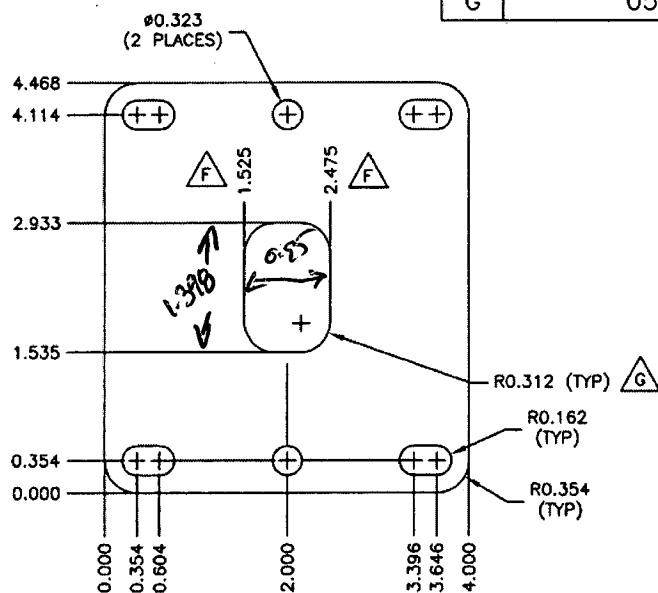
Measured by: <u>BS</u>	Audited by: <u>EP</u>	Prototype Approval: N/A
Date: <u>07-08-23</u>	Date: <u>07/08/23</u>	Date: N/A

Rev	Date	Change	Revised by	Approved
A	06.09.08	New Issue	KJ/JLM	<i>[Signature]</i>

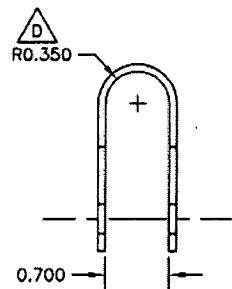
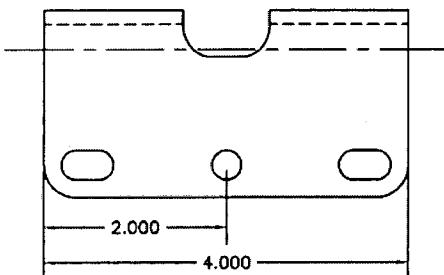


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>IP</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2281	REV. G SHEET 1 OF 1
DATE 05.06.07		TITLE JACK SADDLE	SCALE 1:2
A	94.10.14	NEW ISSUE	
B	94.10.18	DIMENSION WAS 2.878	
C	94.11.04	ADD TOOLING NOTCH	
D	98.03.27	R0.350 WAS R0.280	
E	04.11.18	REMOVE TOOLING NOTCHES	
F	05.03.16	REDESIGN FLAT PATTERN	
G	05.06.07	REDESIGN FLAT PATTERN	

**RELEASED**  
*[Signature]*  
05/08/11



FLAT LAYOUT



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 34181

D2281 JACK SADDLE

- 1) MATERIAL: 304/316 SS, 0.080 THICK (REF DART SPEC. M304S14GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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